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Europäisches Patentamt

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(11)

EP 0 712 738 A1

(12)

# EUROPEAN PATENT APPLICATION

(43) Date of publication:

Date of publication  
**22.05.1996 Bulletin 1996/21**

(51) Int Cl. 6: B60C 9/08, B60C 9/18

(21) Application number: 95308153.6

(22) Date of filing: 14.11.1995

(84) Designated Contracting States:  
**DE FR GB IT**

(30) Priority: 15.11.1994 JP 306789/94

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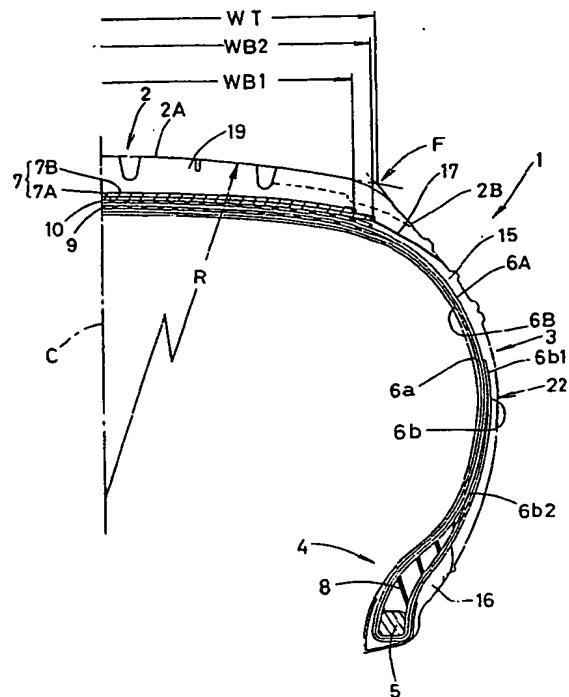
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**(54) Pneumatic radial tyre**

(57) A pneumatic radial tyre comprising a carcass (6) comprising an outer ply (6A) and an inner ply (6B), each carcass ply being made of organic fibre cords and extending between bead portions (4) through a tread portion (2) and sidewall portions (3), a belt (7) disposed radially outside the carcass (6) in the tread portion (2) and comprising a radially inner ply (7A) and a radially outer ply (7B), each belt ply being made of steel belt cords, characterised by a first damping rubber layer (9) disposed between the outer carcass ply (6A) and the inner carcass ply (6B), the first damping rubber layer (9) having an axial width (W1) of 0.8 to 1.2 times the axial width (WB2) of the radially inner belt ply (7A) and a thickness (T1) of 0.5 to 2.0 mm, and a second damping rubber layer (10) disposed between the outer carcass ply (6A) and the radially inner belt ply (7A), the second damping rubber layer having an axial width (W2) of 0.8 to 1.2 times the axial width (WB2) of the radially inner belt ply (7A) and a thickness (T2) of 0.5 to 2.0 mm.

Fig. 1



## Description

The present invention relates to a pneumatic radial tyre, more particularly an improvement in the internal structure in the tread portion which is capable of reducing noise during running without sacrificing running performance.

Recently, there is a great demand for a low noise tyre in various categories such as passenger tyre, RV tyre, 4WD car tyre and the like.

In order to reduce the running noise of a tyre, many efforts have been made to improve the tread pattern especially in case of the passenger tyres. However, particularly in the cases of RV tyres, 4WD car tyres and the like the tread patterns of which are defined by wide grooves and circumferentially separated tread elements such as blocks, it is difficult to reduce the running noise by improving only the tread pattern. Therefore, it has been suggested to decrease the hardness of the tread rubber, that of the topping rubber for the belt, and/or the volume of the tread grooves.

However, if the tread rubber hardness is decreased, the cornering power decreases. As a result, steering stability is deteriorated.

If the belt topping rubber hardness is decreased, similar problems arise because the reinforcing effect of the belt decreases.

If the tread groove volume is decreased, the wet grip performance and braking performance are deteriorated.

Such deterioration in the running performance is especially remarkable in snow and mud & snow tyres. Therefore, it is not preferable to employ the above-mentioned methods even though the running noise of such a tyre is larger than that of the passenger tyres. Thus, the running noise can not be fully reduced.

The above-mentioned noise reducing methods are generally for decreasing the amplitude of the generated noise. However, even if the generated noise is reduced, or the amplitude of vibrations of the tread portion is reduced, it is liable to be amplified by resonance of the tyre when transmitted from the tread portion to the sidewall portions.

In the frequency range of about 1000 to 1250 Hz, such a phenomenon is remarkable, and as a result, it is found that the running noise is not reduced since the human ears are sensitive to this frequency range.

As another possibility, if a rubber layer is disposed between the plies of a tread reinforcing belt, the running noise may be decreased. However, as the belt stiffness is decreased, the cornering power is greatly decreased, and running performance such as steering stability is greatly deteriorated.

It is therefore, an object of the present invention to provide to a pneumatic radial tyre the running noise of which is reduced without sacrificing running performance.

According to one aspect of the present invention, a pneumatic radial tyre comprises a carcass comprising an outer ply and an inner ply, each carcass ply being made of organic fibre cords and extending between bead portions through a tread portion and sidewall portions, a belt disposed radially outside the carcass in the tread portion and comprising a radially inner ply and a radially outer ply, each belt ply made of steel belt cords, a first damping rubber layer disposed between the outer carcass ply and the inner carcass ply, the first damping rubber layer having an axial width (W1) of 0.8 to 1.2 times the axial width (WB2) of the radially innermost belt ply and a thickness (T1) of 0.5 to 2.0 mm, a second damping rubber layer disposed between the outer carcass ply and the radially innermost belt ply, the second damping rubber layer having an axial width (W2) of 0.8 to 1.2 times the axial width (WB2) of the radially innermost belt ply and a thickness (T2) of 0.5 to 2.0 mm.

Preferably, each of the first and second damping rubber layers has a JIS(A) hardness of 55 to 65 degrees, a 100% modulus of 20 to 30 kgf/sq.cm, and a loss tangent of 0.05 to 0.15.

As the second damping rubber layer is disposed between the belt and carcass, the transmission of vibration of the belt to the carcass is decreased and at the same time the vibration is absorbed.

If the vibration of the belt, which has been already damped by the second damping layer, is transmitted to the carcass crown portion, as the first damping rubber layer is disposed between the carcass plies, the vibration is again absorbed, and the transmission from the carcass crown portion to the sidewall portions is decreased.

As a result, in the frequency range of about 1000 to 1250 Hz in particular, the generation of vibrations as well as the transmission from the tread portion to the sidewall portions are effectively decreased. As a result, the running noise in such a frequency range is effectively reduced.

According to the invention, no damping rubber layer is disposed between the belt plies. Therefore, the rigidity of the belt is maintained.

Since the rigid belt floats on the relatively soft damping layer, if the belt is vibrated, the vibrations are quickly dispersed in the circumferential direction to be absorbed by the damping layers.

Further, as the first damping rubber layer is disposed in only the crown portion, the rigidity of the carcass in the sidewall portions is not decreased.

The tread portion is therefore, reinforced by the rigid belt and the sidewall portions by the carcass. Thus, the tyre as a whole is fully reinforced, and the running performance is improved.

If the JIS(A) hardness of the damping rubber layers is less than 55 degrees, it is difficult to control or absorb the belt vibration. If the hardness is more than 65 degrees, the transmission from the belt to the carcass increases and

the running noise can not be reduced. Further, the tread rigidity is liable to excessively increase, which deteriorates ride comfort and increases a low frequency noise. If the thickness of the damping rubber layers is more than 2 mm, the tread rigidity decreases and the steering stability is deteriorated. Further, the tyre weight unfavourably increases, and tyre uniform such as the force variation is liable to be disturbed. If the thickness is less than 0.5 mm, the above-mentioned advantages can not be obtained.

If the width W1, W2 of the damping rubber layers is less than 0.8 times the width WB2 of the radially innermost belt ply, the above-mentioned advantages can not be obtained. Further, the ground pressure distribution is liable to become uneven, which results in uneven tread wear and a decrease in the steering stability. If the width W1, W2 is more than 1.2 times the width WB2, the steering stability decreases. Further, the tyre weight increases and the tread thickness is liable to become uneven.

An embodiment of the present invention will now be explained in conjunction with the drawings in which

Fig.1 is a cross sectional view of an embodiment of the present invention; and

Fig.2 is an enlarged cross sectional view of the tread portion thereof.

In Fig.1, a pneumatic radial tyre 1 of the present invention comprises a tread portion 2 with axial edges, a pair of axially spaced bead portions 4, a pair of sidewall portions 3 extending therebetween, a pair of bead cores 5 each disposed in each of the bead portions 3, a carcass 6 extending between the bead portions 3, and a belt 7 disposed radially outside the carcass 6 in the tread portion 2.

The carcass 6 comprises at least two plies, an outer carcass ply 6A and an inner carcass ply 6B. The carcass 6 in this embodiment comprises only the two plies 6A and 6B. Each of the plies 6A and 6B comprises a toroidal main portion extending from one of the bead cores 5 to the other through the sidewall portions 3 and tread portion 2, and a pair of turnup portions 6b each turned up in each bead portion 4 around the bead core 5 from the axially inside to the outside thereof.

The carcass cords in each ply 6A, 6B are radially arranged at an angle of 75 to 90 degrees with respect to the tyre equator C. The carcass cords are rubberised by a topping rubber having a JIS(A) hardness of 50 to 60 degrees. For the carcass cords, organic fibre cords, e.g. nylon, rayon, polyester, aromatic polyamide or the like may be used.

The turnup portion 6b2 of the inner carcass ply 6B has an upper end which is disposed slightly, for example about 5 mm, radially inward of the maximum tyre section width point 22.

The turnup portion 6b1 of the outermost carcass ply 6A extends radially outwardly beyond the upper end of the turnup portion 6b2 by a certain distance, for example about 20 mm so as to completely cover the turnup portion 6b2.

Between the main portion 6a and each turnup portion 6b of the carcass 6, a rubber bead apex 8 is disposed, the bead apex 8 extending and tapering radially outwardly from the bead core 5, so as to reinforce the bead portion 4 and sidewall lower portion in co-operation with the carcass turnup portion 6b.

The belt 7 comprises at least two plies, a radially innermost belt ply 7A and a radially outer next belt ply 7B. Each of the belt plies 7A and 7B is made of steel cords laid at an angle of 10 to 45 degrees with respect to the tyre equator C and rubberised by a topping rubber having a JIS(A) hardness of 50 to 60 degrees. The belt plies 7A and 7B are oriented in different directions so that the cords in the belt ply 7A cross the cords in the belt ply 7B.

The axial width WB1 of the radially outer belt ply 7B is in the range of from 80 to 90 % of the tread width WT.

The axial width WB2 of the radially innermost belt ply 7A is larger than the width WB1 and in the range of from 90 to 100 % of the tread width WT.

Here, the tread width WT is defined as the axial width between intersecting points F of an extension line of the tread surface line 2A and an extension line of the buttress surface line 2B. This definition is applied to a rounded shoulder tyre as shown in Fig.1. However, if the tyre shoulder is edged, the tread width WT is defined as the axial width between those edges.

The tread surface 2A in this embodiment is, in the tyre meridian section, defined by a single radius arc having the centre on the tyre equatorial plane C and a radius of curvature R of from 1.0 to 2.5 times the tyre maximum width.

The tread portion 2 is, as shown in Fig.2, provided with two damping layers 9 and 10 each of which is a thin rubber sheet.

The first damping rubber layer 9 is disposed between the outer carcass ply 6A and the inner carcass ply 6B. The second damping rubber layer 10 is disposed between the outer carcass ply 6A and the radially innermost belt ply 7A.

The first damping rubber layer 9 extends continuously between its axial edges, and the axial width W1 between the edges is in the range of from 0.8 to 1.2 times the above-mentioned belt ply width WB2. Each edge portion thereof is tapered so as to avoid stress concentration of the carcass plies at the point corresponding to the edge. This tapered edge portion 9b has a width of not more than 0.1 times, preferably not more than 0.06 times, the overall width W1. The main portion defined between the tapered edge portions 9b has a substantially constant thickness T1 of from 0.5 to 2.0 mm, more preferably from 0.8 to 1.2 mm.

The second damping rubber layer 10 has a substantially constant thickness T2 of from 0.5 to 2.0 mm, more pref-

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rably 0.8 to 1.2 mm, over the substantially overall width thereof. The axial width W2 thereof is in the range of from 0.8 to 1.2 times the above-mentioned width WB2.

In this embodiment, the width W2 is less than the width W1, which is substantially equal to the width of the main portion 9a of the first damping rubber layer 9.

5 In the Figures, the edge portions are not tapered, but it is also possible to taper the edges as the first damping rubber layer.

10 The first and second damping rubber layers 9 and 10 are made of a rubber compound harder than the carcass rubber and the belt topping rubber. The JIS(A) hardness thereof is in the range of from 55 to 65 degrees, but 3 to 15 degrees larger than that of the topping rubber.

15 Preferably, the first and second damping rubber layers 9 and 10 have a loss tangent or loss factor of from 0.05 to 0.15, and a 100% modulus (M100) of from 20 to 30 kgf/sq.cm. If these limitations are not satisfied, a separation damage from the carcass 6 and belt 7 is liable to occur and the tread durability decreases.

15 The loss tangent and complex elastic modulus (E\*) are measured in the following conditions, a temperature of 70 degrees C, initial strain of 10%, frequency of 10Hz and amplitude of 2%, using a viscoelastic spectrometer manufactured by Iwamoto Seisakusho in Japan.

20 The above-mentioned damping rubber layers 9 and 10 are formed by winding a thin rubber sheet and jointing the circumferential edges thereof usually by slightly overlapping one another. The joint part of the first damping rubber layer 9 is disposed at a circumferentially different position from that of the second damping rubber layer 10, for example, 180 degrees differed so as to improve the force variation.

25 In each sidewall portion 3, a sidewall rubber 15 is disposed on the axially outside of the carcass 6, the hardness of which is less than that of the second damping rubber layer 10. The radially inner and outer edges of the sidewall rubber 15 are tapered, and the inner edge is overlapped and connected with a tapered radially outer edge of a bead rubber 16, the bead rubber 16 extending radially outwardly from the bead heel. The outer edge is also overlapped and connected with a tapered axial edge of a tread rubber 19 using a thin bonding layer 17 disposed therebetween. The bonding layer 17 is made of a rubber compound having a hardness between those of the tread rubber 19 and sidewall rubber 16. One end of the bonding layer 17 reaches to the tyre surface, and the other end to the radially outside of the radially outermost belt ply so as to cover all the belt ply edges. The radially outer edge of the sidewall rubber 15 is inserted into a space H between the axial edge of the second damping rubber layer 10 and the axial edge of the belt 7, in this embodiment that of the widest innermost belt ply 7A.

30 In this embodiment, the same rubber compound is used for the first and second damping rubber layers 9 and 10, which is usually preferable for the tyre uniformity. It is however, possible to use different rubber compounds.

An example of the rubber compound which satisfies the above-mentioned limitations for the JIS(A) hardness, loss tangent and 100% modulus is as follows.

		(parts by weight)
35	NR	75.00
40	SBR	25.00
	Carbon black (HAF)	45.00
45	Aromatic oil	9.00
	Stearic acid	2.00
	Hydrozincite	5.00
50	Mineral oil	0.75
	Sulfur	3.00
	Accelerator	1.50
	JIS(A) hardness	60 deg.
	Loss tangent	0.09
	Complex elastic modulus	48 kgf/sq.cm
	100% modulus (M100)	23 kgf/sq.cm
	300% modulus (M300)	110 kgf/sq.cm

55 Test tyres of size 265/70R16 having the same structure shown in Fig.1 except the damping layers were made and tested for passing noise, steering stability and rolling resistance. The specifications and test results are shown in Table 1.

## 1) Passing noise

According to the "Test Procedure for Tyre Noise" specified in Japanese JASO-C606, a four-wheel-drive car provided with test tyres was coasted for 50 metre distance at a speed of 57 km/h in a straight test course, and the maximum noise sound level in dB(A) was measured with a microphone set at 1.2 metre height from the road surface and 7.5 metre sideways from the running centre line in the midpoint of the course.

## 2) Steering stability

During running the test car, steering stability was evaluated by the driver's feeling the results are indicated by an index based on that the conventional tyre is 100.

## 3) Rolling resistance

The tyre was mounted on a standard rim and inflated to 1.9 kg/sq.cm, and the rolling resistance was measured at a running speed of 80 km/H under a tyre load of 275 kg, using a drum type tyre rolling resistance tester with a drum diameter of 1707.6mm. The results are indicated by an index based on that the conventional tyre is 100. The smaller the value, the smaller the rolling resistance.

It was confirmed from the tests that, in comparison with the conventional tyre, the example tyres were reduced in maximum passing noise sound level while substantially maintaining steering stability.

As described above, in the pneumatic radial tyre according to the present invention, due to the two damper layers passing noise was reduced without sacrificing running performance such as the steering stability and the like.

The present invention is suitable for applications such as snow tyre, mud & snow tyres, and 4WD vehicle tyres.

Table 1

Tyre	Conven.	Ref.1	Ex.1	Ex.2	Ex.3	Ref.2
First damping layer	----	----	1.0	1.0	0.5	----
Thickness T1 (mm)	----	----	1.0	1.0	1.0	----
Width W1 (x WB2)	----	----	2.0	1.0	0.5	3.0
Second damping rubber	----	----	1.0	1.0	1.0	1.0
Thickness T2 (mm)	----	2.0	1.0	2.0	0.5	3.0
Width W2 (x WB2)	----	1.0	1.0	1.0	1.0	1.0
Passing noise						
1000 Hz dB(A)	58.98		57.94			
1250 Hz dB(A)	58.36		57.36			
Overall dB(A)	71.4	69.9	70.0	69.7	70.3	69.8
Steering stability	100	90	100	90	100	85
Rolling resistance	100	98	100	98	100	95

Note) The rubber compound shown in Table 1 was used for the first and second damping layers.

## Claims

1. A pneumatic radial tyre comprising a carcass (6) comprising an outer ply (6A) and an inner ply (6B), each carcass ply being made of organic fibre cords and extending between bead portions (4) through a tread portion (2) and sidewall portions (3), a belt (7) disposed radially outside the carcass (6) in the tread portion (2) and comprising a radially inner ply (7A) and a radially outer ply (7B), each belt ply being made of steel belt cords, characterised by a first damping rubber layer (9) disposed between the outer carcass ply (6A) and the inner carcass ply (6B), the first damping rubber layer (9) having an axial width (W1) of 0.8 to 1.2 times the axial width (WB2) of the radially inner belt ply (7A) and a thickness (T1) of 0.5 to 2.0 mm, and a second damping rubber layer (10) disposed between the outer carcass ply (6A) and the radially inner belt ply (7A), the second damping rubber layer having an axial width (W2) of 0.8 to 1.2 times the axial width (WB2) of the radially inner belt ply (7A) and a thickness (T2) of 0.5 to 2.0 mm.
2. A tyre according to claim 1, characterised in that the thickness T1 of the first damping layer (9) and the thickness

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of the second damping layer (10) are in the range of 0.8 to 1.22mm.

3. A tyre according to claim 1 or 2, characterised in that the first damping layer has each of its edge regions tapered, each said edge regions being not more than 0.1 times the overall width W1.

5 4. A tyre according to claim 1 or 2, characterised in that the first damping layer has each of its edge regions tapered, each said edge regions being not more than 0.06 times the overall width W1.

10 5. A tyre according to claim 1, 2, 3 or 4, characterised in that each of the first and second damping rubber layers has a JIS(A) hardness of 55 to 65 degrees, a 100% modulus of 20 to 30 kgf/sq.cm, and a loss tangent of 0.05 to 0.15.

6. A tyre according to any of claims 1 to 5, characterised in that the first and second damping rubber layers (9,10) are of a compound harder than the carcass rubber and the belt topping rubber.

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Fig. 1

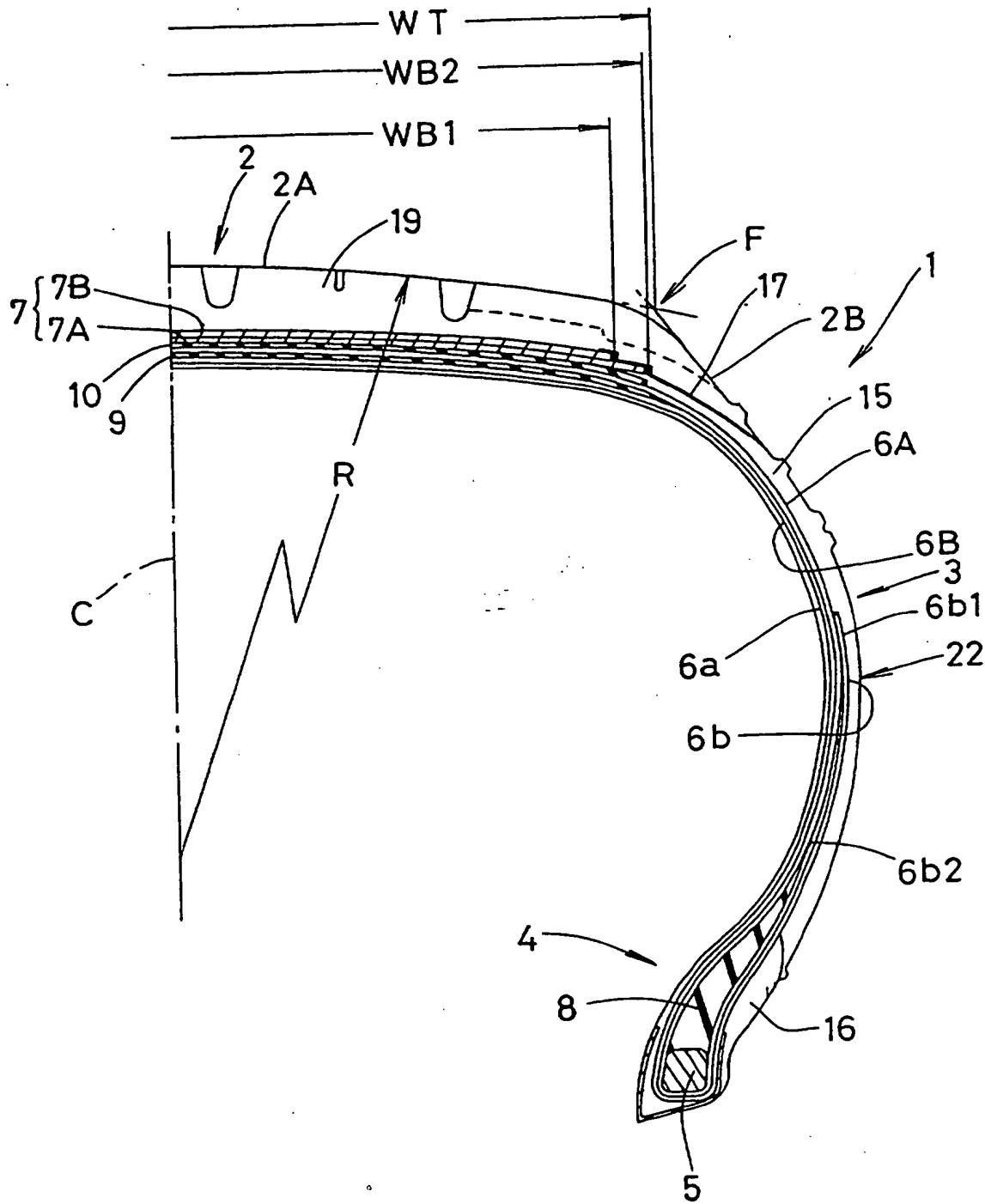
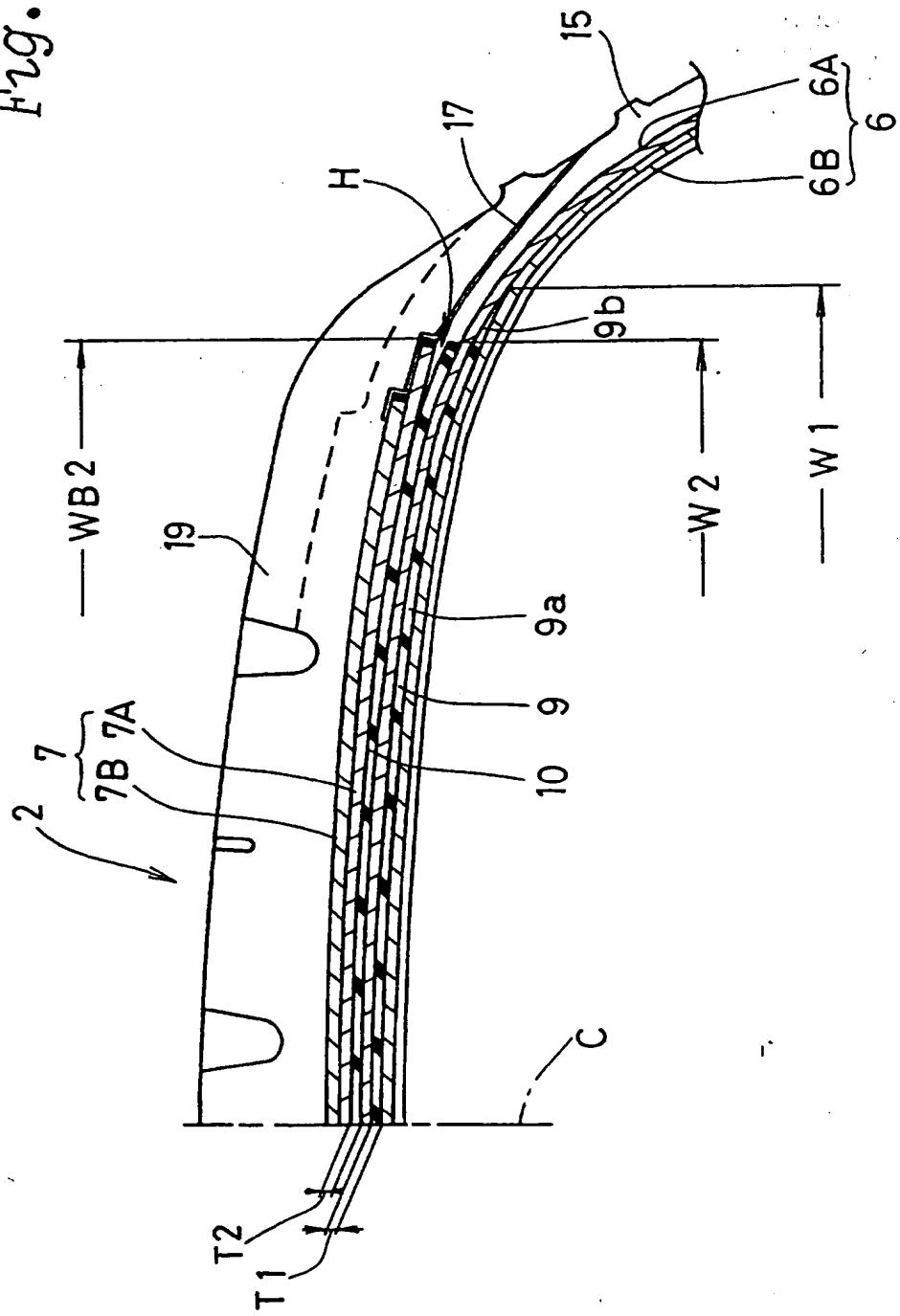


Fig. 2





DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
A	DE-B-10 39 382 (CONTINENTAL) * claims; figures *	1	B60C9/08 B60C9/18
A	DE-C-414 162 (MORGAN&WRIGHT) * claims; figures *	1	
A	EP-A-0 620 129 (SUMITOMO RUBBER IND) 19 October 1994 * claims; figures *	1,5,6	
A	FR-A-1 199 616 (MICHELIN ET CIE) * claims; figures *	1,6	
A	FR-A-2 400 440 (UNIROYAL GMBH.) * claim 7; figure *	1	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
Place of search		Date of completion of the search	Examiner
THE HAGUE		1 March 1996	Baradat, J-L
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ..... & : member of the same patent family, corresponding document	
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			

